



A/C or Part Cyclic Friction Parts  
Work Order # 2014-69  
Date Sep 10/14

[illegible]

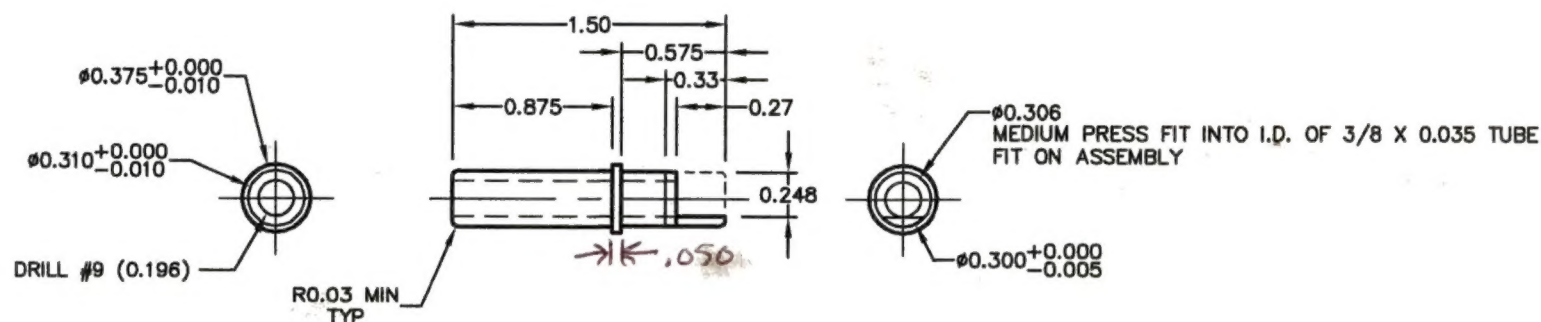
2014-69 x 100

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



## 01 RETAINER BUSHING

		95222-01	01	RETAINER BUSHING	304 STAINLESS STEEL	ASTM A479	#0.375 ROD	
01	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS							
				APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 850-8087 fax: (403) 850-8338 www.aerodesign.ca		
				DRAWN: JEFF CLARKE	18 OCT 2012			
				CHECKED: E. BURGAIN				
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - RETAINER BUSHING		
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.				
SHEET 1 OF 1		A4	95222	0				

- cut  $1\frac{9}{16}$ "

use coolant for all steps

- deburr one end

~~Face one end to length~~

- set collet stop

- face one end (.925" stick out from collet)

- turn to length up to collar

- deburr to 45° with custom groove tool or file.

- center drill end 425 RPM

- drill bore 1" deep #9 drill 1380 RPM

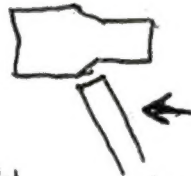
- deburr bore end

→ turn part around

- Face end 1380 RPM

- Turn O.D. to collar 1380 RPM

- Turn small end with taper using angled cutter to length and dia.



1380 RPM

- deburr to 45° corners of end and collar with modified groove tool or file. 1380 RPM

- center drill end 425 RPM

- drill bore till it meets other bore. 425 RPM #9 drill

- deburr bore end

To mill cut-out.

- 1/2" 4 flute coated carbide end mill

- one climb pass @ 1200 RPM hand feed "Y" axis.

- clamp with supplied split tool and use stop in vise

Final steps

- deburr on fibre wheel

- inspect

- Tag

Bolts

5/16 24

Stainless

PO# 13067



2014-69 x 20

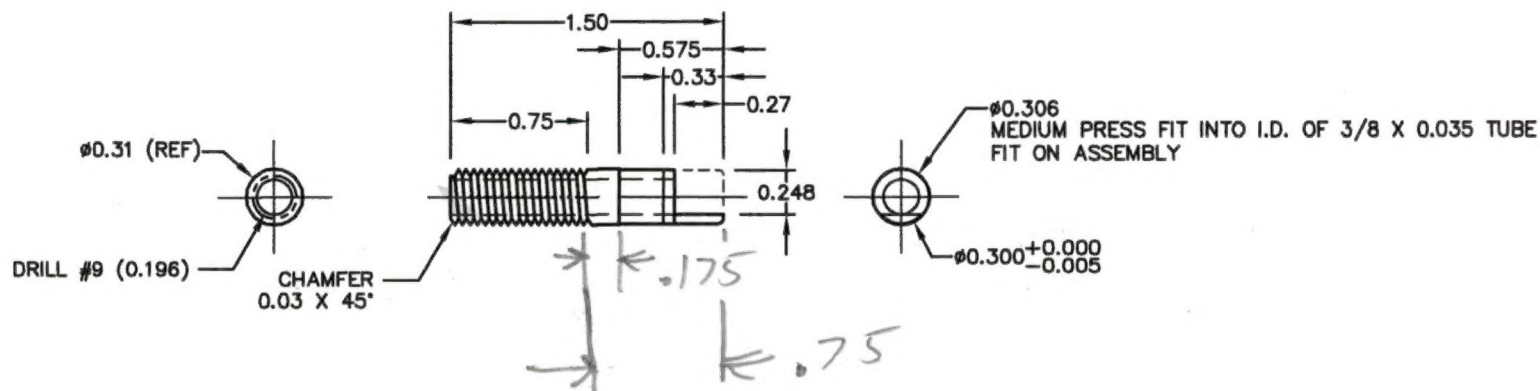
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		


# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

Done Sept 16/2014



① RETAINER BUSHING

		95252-01	01	RETAINER BUSHING	STAINLESS STEEL	GRADE 18.8	5/16-18 X 2 BOLT			
01	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE			
QTY	LIST OF MATERIALS									
				APPROVALS		DATE			<b>AERO DESIGN LTD.</b> 9886A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.488.8976      www.aerodesign.ca	
				DRAWN: JEFF CLARKE		19 MAR 2014				
				CHECKED: JASON REKVE		07 AUG 2014				
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX    ±0.010                      ±1/2" X.XX    ±0.03 X.X    ±0.1		BELL 206A, 206B – UP TO S/N 1651 CYCLIC FRICTION REPLACEMENT PARTS – RETAINER BUSHING				
				SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.		
				SHEET 1 OF 1		A4	95252	0		

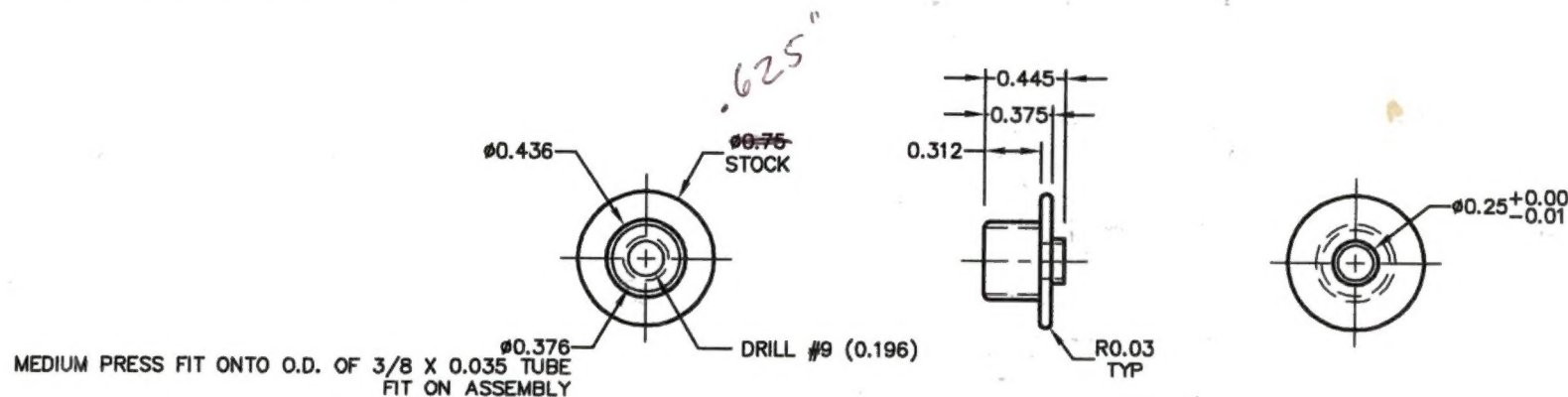
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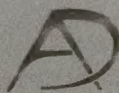
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



01 CAP

95224-01		01	CAP		304 STAINLESS STEEL	ASTM A479	Ø0.75 ROD			
01	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE			
QTY	LIST OF MATERIALS									
			APPROVALS		DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8335 www.aerodesign.ca			
			DRAWN: JEFF CLARKE		18 OCT 2012					
			CHECKED: E. BURGOIN							
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - CAP					
			SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
			SHEET 1 OF 1		A4		95224		0	



**Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

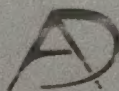
Nomenclature: Retainer Bushing No. of pieces: 100  
Manufacturer: Aero Design Ltd.  
Part No.: 95222-01 Serial No.: NSN  
TTSN: NP TSO: N/A Rem.: N/A  
Work Order No.: 2014-69  
Remaining Tasks to be Performed: \_\_\_\_\_

Signature: Olava Behn  
Date: 16 Sep 14 Lic. No. / SCA AD 01

Form# 20.E.02

Rev. 1 24 April 2014

Serviceable

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AMF 73-04

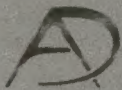
Nomenclature: Cap No. of pieces: 20  
Manufacturer: Aero Design Ltd.  
Part No.: 95254-01 Serial No.: NSN  
TTSN: NP TSO: N/A Rem.: N/A  
Work Order No.: 2014-69  
Remaining Tasks to be Performed: \_\_\_\_\_

Signature: Olava Behn  
Date: 16 Sep 14 Lic. No. / SCA AD 01

Form# 20.E.02

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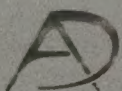
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AMF 73-04

**Serviceable**

**Remarks**

Material PO# 12074



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**Serviceable**

**Remarks**

Material PO# 12044



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Cap No. of pieces: 100

Manufacturer: Aero Design Ltd.

Part No.: 95224-01 Serial No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2014-69

Remaining Tasks to be Performed: \_\_\_\_\_

Signature: Jada Rym

Date: 16 Sep 14 Lic. No. / SCA AD 01

Form# 20.E.02

Rev. 1 24 April 2014

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9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Retainer Bushing No. of pieces: 20

Manufacturer: Aero Design Ltd.

Part No.: 95252-01 Serial No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2014-69

Remaining Tasks to be Performed: \_\_\_\_\_

Signature: Jada Rym

Date: 16 Sep 14 Lic. No. / SCA \_\_\_\_\_

Form# 20.E.02

Rev. 1 24 April 2014

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**Aero Design Ltd.**

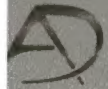
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AMF 73-04

**Serviceable**

Material PO# <sup>Remarks</sup> 12044.



**Aero Design Ltd.**

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AMF 73-04

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Material PO# <sup>Remarks</sup> ~~160~~ 13067 OK



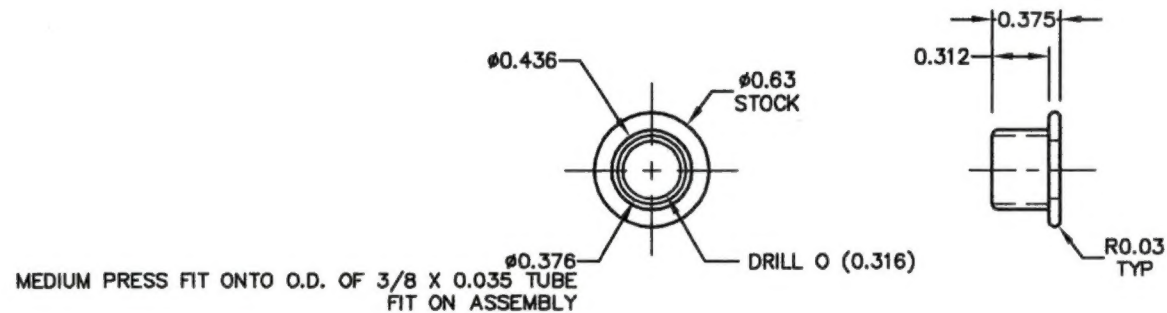
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#### NOTES

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01 CAP

		95254-01		01	CAP	304 STAINLESS STEEL		ASTM A479	#0.625 ROD				
01	PART NO.		ITEM	DESCRIPTION		MATERIAL		MATERIAL SPEC		STOCK SIZE			
QTY	LIST OF MATERIALS												
						APPROVALS		DATE			<b>AERO DESIGN LTD.</b>  9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.469.8976      www.aerodesign.ca		
						DRAWN: JEFF CLARKE		19 MAR 2014					
						CHECKED: JASON REKVE		07 AUG 2014					
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						BELL 206A, 206B – UP TO S/N 1651 CYCLIC FRICTION REPLACEMENT PARTS – CAP							
						SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
						SHEET 1 OF 1		A4		95254		0	